

Date: Thursday, 23/10/2008 10:54:14 AM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206/OH-58 SADDLE, INBOARD, LEFT SIDE - UNDER REVIEW		
Job Number	: 42890		Part Number	: D29391UP		
Estimate Number	: 12927		Drawing Number	: D2939 REV C		
P.O. Number	:		Project Number	: N/A		
This Issue	: 23/10/2008 S.O. No. :		Drawing Revision	: C		
Prsht Rev.	: NC		Material	:		
First Issue	: / /		Due Date	: 15/11/2008 Qty: 8 Um: Each		
Previous Run	: 41724		10/10/08			
Written By	:		JL 08-10-23			
Checked & Approved By	:					
Comment	: Est Rev:A New Issue 07-07-04 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101001	Saddle Billet	
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Issue material from stock: 7075-T7351 QQ-A-250/12 Cut Size 2.0 x 6.25 X 6.00 Grain Along Long 6.00 Length Batch No: B84872			
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
<b>Comment:</b> HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 5-Deburr			
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
<b>Comment:</b> CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet			
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
<b>Comment:</b> INSPECT ALL DIM TO DIM SHEET			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 23/10/2008 10:54:14 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE - UNDER  
REVIEW

Job Number: 42890

Part Number: D29391UP

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
8.0	PACKAGING 1	PACKAGING RESOURCE #1
9.0	QC21	FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order: 42890				
Description: 206 Saddle, Inboard, Left side				Part Number: D2939-1				
Inspection Dwg: D2939 Rev. C				Page 1 of 1				

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions					
				1	2	3	4	By	
A	0.100	0.140		.113	.113	.116	.116		
B	0.100	0.140		.113	.113	.111	.117		
C	0.100	0.140		.119	.102	.115	.111		
D	0.210	0.230		.218	.220	.221	.219		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.104	.121	.121	.121		
O	0.540	0.560		.545	.559	.550	.551		
P	0.490	0.510		.500	.502	.502	.501		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.742	2.742	2.742	2.742		
S	0.240	0.270		.256	.251	.256	.261		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.319	.319	.319	.319		
X	1.250	1.270		1.259	1.256	1.259	1.251		
Y	1.565	1.585	DT8695 A/B	1.566	1.581	1.585	1.580		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L.	Audited by:	<i>no</i>
Date:	08/11/03	Date:	<i>08/11/03</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>JK</i>	<i>JK</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD			Work Order: 42890
Description: 206 Saddle, Inboard, Left side		Part Number:	D2939-1
Inspection Dwg:	D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

			Recorded Actual Dimensions						
Dim	Min	Max	Go/No Go Gauge	15	16	17	18	By	Date
A	0.100	0.140		.116	.120	.121	.117		
B	0.100	0.140		.117	.120	.121	.118		
C	0.100	0.140		.116	.110	.112	.112		
D	0.210	0.230		.217	.219	.220	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.105	.108	.108	.108		
O	0.540	0.560		.550	.555	.550	.551		
P	0.490	0.510		.502	.503	.500	.501		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.742	2.742	2.742	2.742		
S	0.240	0.270		.261	.263	.265	.264		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.319	.319	.319	.319		
X	1.250	1.270		1.252	1.250	1.253	1.251		
Y	1.565	1.585	DT8695 A/B	1.581	1.585	1.583	1.585		
Z	0.178	0.198		.186	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JL	Audited by:	RR
Date:	08/11/03	Date:	08/11/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	JLM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

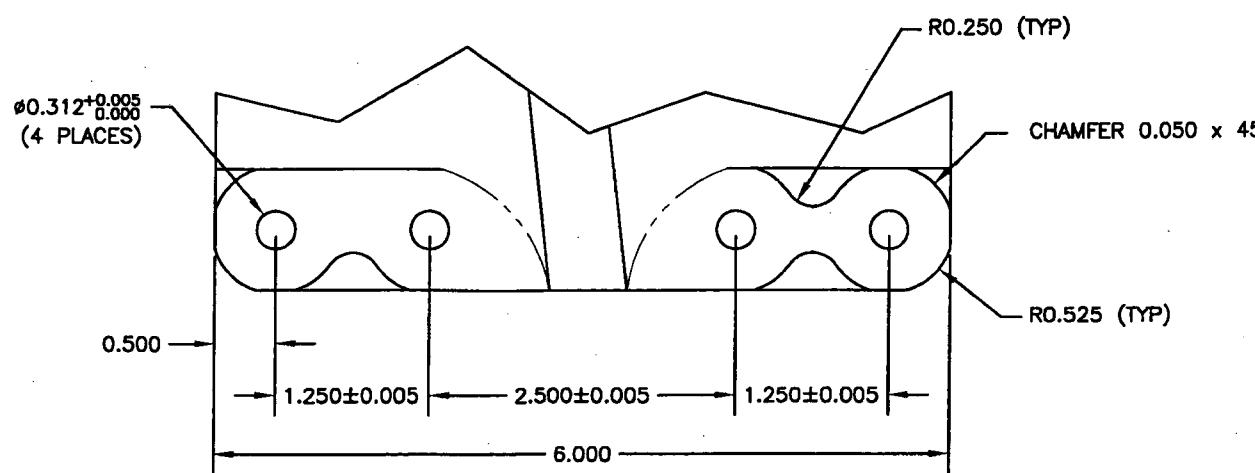
DART AEROSPACE LTD				Work Order:	42890
Description: 206 Saddle, Inboard, Left side				Part Number:	D2939-1
Inspection Dwg: D2939 Rev. C				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

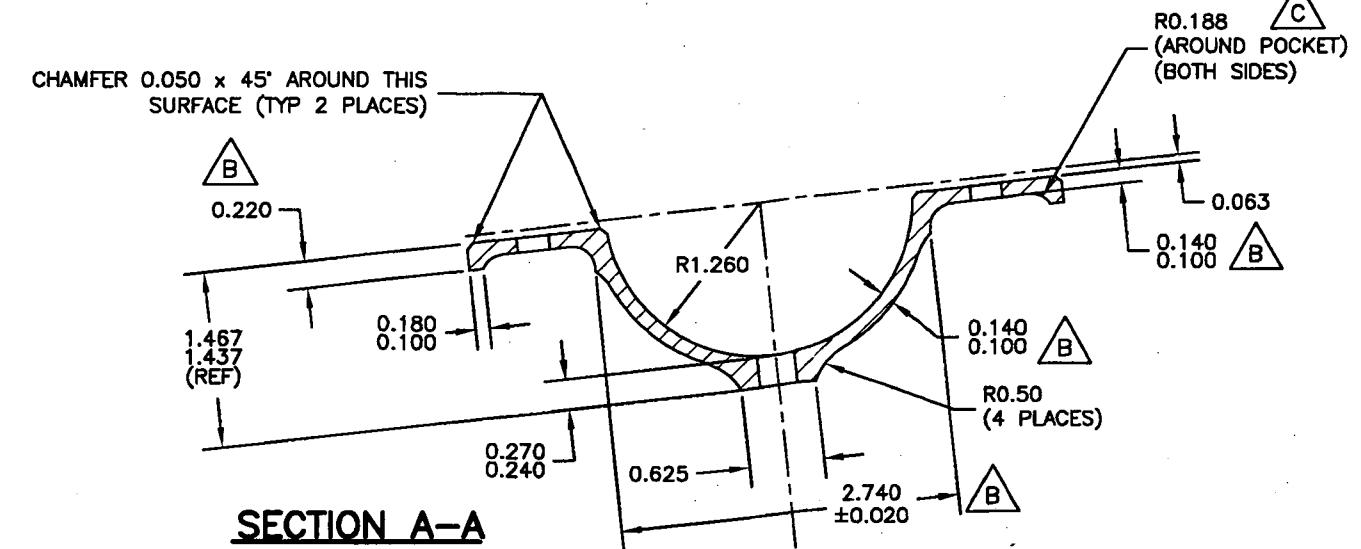
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.117	.120				
B	0.100	0.140		.119	.120				
C	0.100	0.140		.113	.118				
D	0.210	0.230		.217	.218				
E	1.245	1.255		1.280	1.280				
F	1.245	1.255		1.280	1.280				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.510	.510				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.258	.258				
L	0.312	0.317		.314	.314				
M	0.235	0.240		.238	.238				
N	0.100	0.140		.108	.108				
O	0.540	0.560		.552	.551				
P	0.490	0.510		.505	.503				
Q	3.715	3.725		3.720	3.720				
R	2.720	2.760		2.742	2.742				
S	0.240	0.270		.261	.265				
T	0.100	0.180		.140	.140				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.319	.319				
X	1.250	1.270		1.251	1.250				
Y	1.565	1.585	DT8695 A/B	1.585	1.585				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JL	Audited by:	RJ
Date:	08/11/03	Date:	08/11/03

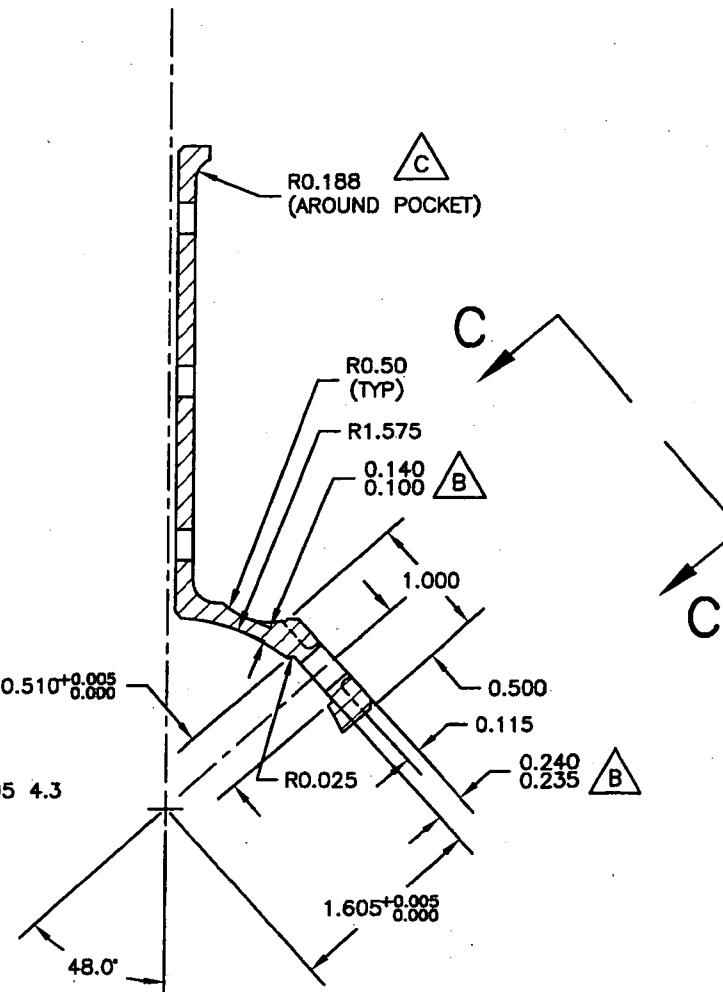
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	JL



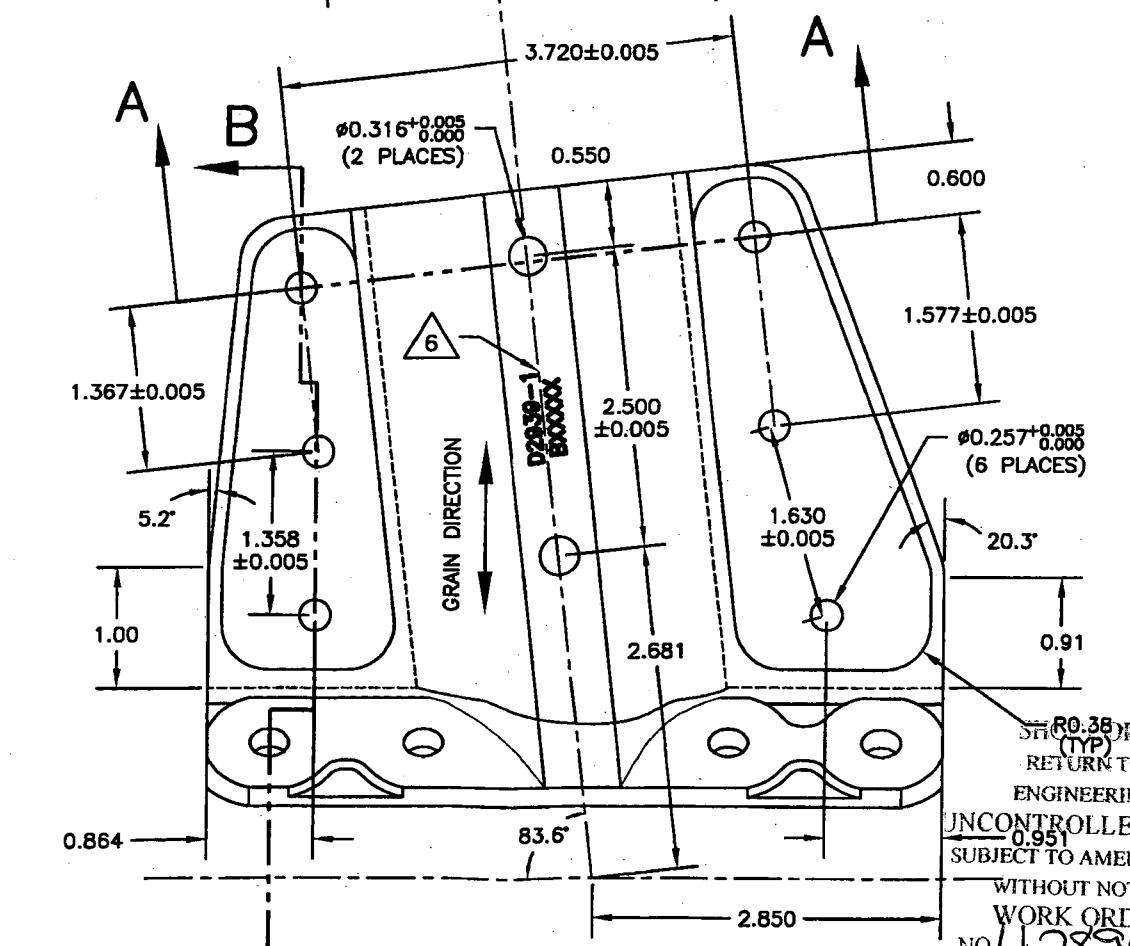
VIEW C-C



SECTION A-A



SECTION B-B



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE

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DART AEROSPACE USA, INC.

DESIGN	4	DRAWN BY	CB	DART	DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	PH	APPROVED	HH	DRAWING NO.	D2939
DATE	06.11.09	TITLE	SADDLE INSIDE	REV. C	SHEET 1 OF 1
SCALE	2:3				

07-02-12